



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7814

Job Sheet 205066



Part No: 647.7814

Job Qty: 16 pcs

Part Name: Fwd Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/27/19

Job Tracking No:

Due Date: 2/21/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV A RQ 13/12/23 VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	Bandsaw - 1	16 pcs	2/21/20	2/21/20	0.00	0.01	Bandsaw - 1	MBD 20/2/19
110	HAAS 4 Axis - B4B	16 pcs	2/21/20	2/21/20	0.04	7.96	HAAS - 1 - B4B	MBD 20/2/19
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
120	QC 2	16 pcs	2/21/20	2/21/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	



DART
AEROSPACE

Container No: S300492



Part: 647.7814
Job No: 205066
Serial No/Batch: S300492
Revision: A
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkebury, ON K64 1K7
CANADA
TEL.: 1 813 832-8200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/09/20



Container No: S300492



Part: 647.7814

Job No: 205066

Serial No/Batch: S300492

Revision: A

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Date: 10/09/20

Plex 12/27/19 12:49 PM Dart.lajeunesse.marie

130 QC 8	16 pcs	2/21/20	0.00 0.00	QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	JRD 20/2/19
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
140 Outsource - 4 - Anodize	16 pcs	2/21/20	0.00 0.00	QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	B.A 20-09-16
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
150 Packaging 2-1 - Receive - B4B	16 pcs	2/21/20	0.00 0.00	QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				ATG001-VC	5
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	

					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
160 QC 6	16 pcs	2/21/20	0.00 0.00	QC 6 - 9		
				QC 6 - 68		
				QC 6 - 61	DAS	
				QC 6 - 40	81	
				QC 6 - 81	9-89	
180 Packaging 3-1 - Stock - B4B	16 pcs	2/21/20	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B	✓	
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B		
190 QC 21 - SA	16 pcs	2/21/20	0.00 0.00	QC 21 - SA - 21		
				QC 21 - SA - 70		
				QC 21 - SA - 53		

Part Op 100 - (Bandsaw) Cut Blanks at 4.625"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB241

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - Issue P/O to ATG : _____ Hard Black Anodize and Prime as per Dwg. 647.7800 Rev. A

150 - (Receive & Inspect for Damage & Mat'l Certs)

160 - (QC6- All purchased or subcontracted products)

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6B1.500X1.500	7075 T6 Bar 1.500 X 1.500 see mat'l	6.1600 ft (.385 ea)	100-Bandsaw -	
	M7075T6S1.500X1.500		1	J138087

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6B1.500X1.500	6	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Bracket	0.800Degrees ± 0.500	1.300 0.300	0.8°	Angle
2	Fwd Bracket	151.500Degrees ± 0.500	152.000 151.000	151.5°	Angle
3	Fwd Bracket	41.900Degrees ± 0.500	42.400 41.400	41.9°	Angle
4	Fwd Bracket	71.700Degrees ± 0.500	72.200 71.200	71.7°	Angle
5	Fwd Bracket	0.436Inches ± 0.002	0.438 0.434	0.437	
6	Fwd Bracket	0.030Inches ± 0.005	0.035 0.025	0.030	
7	Fwd Bracket	2.705Inches ± 0.002	2.707 2.703	2.706	
8	Fwd Bracket	3.955Inches ± 0.002	3.957 3.953	3.955	
9	Fwd Bracket	4.440Inches ± 0.005	4.445 4.435	4.440	
10	Fwd Bracket	0.448Inches ± 0.002	0.450 0.446	0.449	
11	Fwd Bracket	0.177Inches + 0.005 - 0.001	0.182 0.176	0.178	Diameter
12	Fwd Bracket	0.140Inches ± 0.005	0.145 0.135	0.140	
13	Fwd Bracket	45.000Degrees ± 0.500	45.500 44.500	45°	Angle
14	Fwd Bracket	0.170Inches ± 0.005	0.175 0.165	0.170	
15	Fwd Bracket	0.170Inches ± 0.005	0.175 0.165	0.172	
16	Fwd Bracket	0.683Inches ± 0.005	0.688 0.678	0.683	
17	Fwd Bracket	1.155Inches ± 0.005	1.160 1.150	1.155	
18	Fwd Bracket	0.125Inches ± 0.005	0.130 0.120	0.125	Radius

$\phi 0.209 \pm 0.001$
 ± 0.005

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Container No: S300492



Part: 647.7814

Job No: 205066

Serial No/Batch: S300492

Revision:

Inspector:

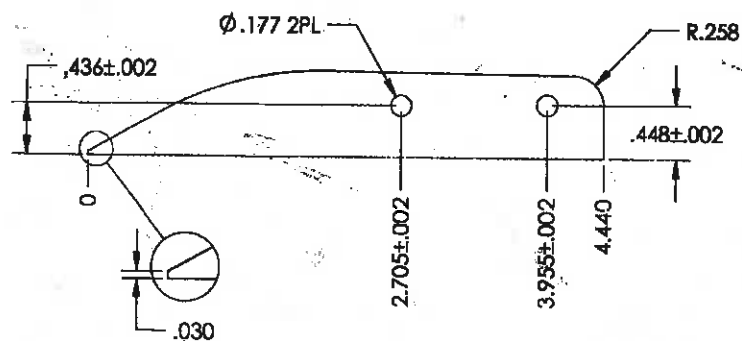
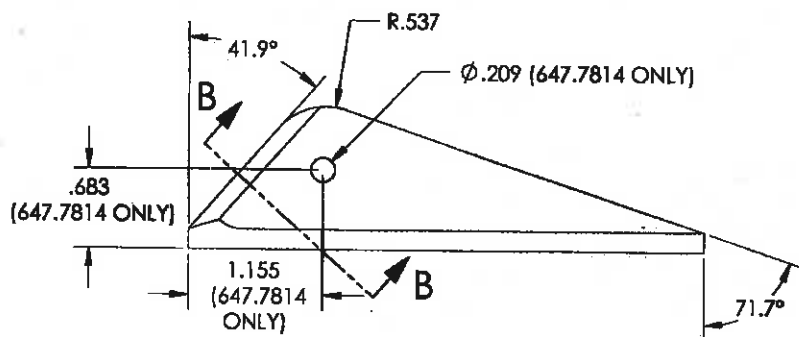
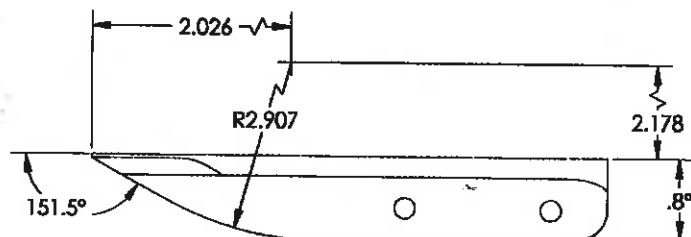
Exp Date:

Instructions: Various STC's

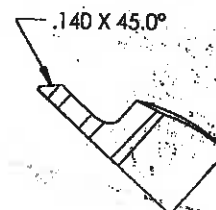
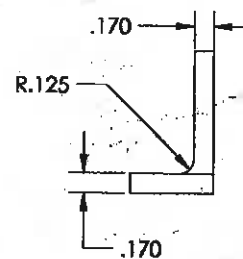
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/28/20

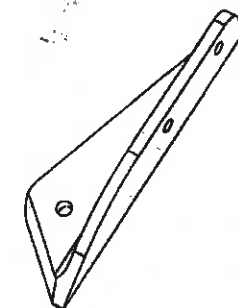
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DBA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.



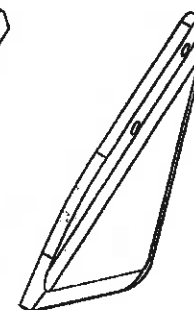
647.7814 SHOWN
647.7815 OPPOSITE



SECTION B-B



647.7814



647.7815

ORIGINAL DATE 04-20-78		11-08-09	
DRAWN BY E. ANDERSON		CHECKED J. BRAY	
DRAWING APPROVAL P. BRAY		APICAL INDUSTRIES INC. 3030 ENTERPRISE CT., VISTA, CA 92081 (760) 724-5300	
CONTRACT NO.		BRACKET	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS .010 2 PLACE DECIMALS .005 1 PLACE DECIMAL .005		SHEET B	REV. A
SCALE NONE		SHEET 4 OF 10	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB047196



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lelande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB047196

PO Date: 9/28/20

Due Date: 10/2/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	213376	RBW6220G00131-8F-1	RBW6220G00131-8F REV.A	Handle -Issue P/O: ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X4		10/2/20	1 pcs	0 pcs	1 pcs	\$18.91/pcs	\$18.91
									OCT 06 2020			
2	212653	RBW6220G00131-8F-2	RBW6220G00131-8F REV.A	Lever -Issue P/O: ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X4		10/2/20	4 pcs	0 pcs	4 pcs	\$18.91/pcs	\$75.64
									OCT 06 2020			
3	212852	RBW6220G00131-8F-1	RBW6220G00131-8F REV.A	Handle -Issue P/O: ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X3		10/2/20	3 pcs	0 pcs	3 pcs	\$18.91/pcs	\$56.73
									OCT 07 2020			
4	212511	647.5710	647.5700 Rev N/C	GPS Mount : Various STC's Outsource process-Anodize per QSI017 4.1.10.1	Firmed X8		10/2/20	8 pcs	0 pcs	8 pcs	\$13.34/pcs	\$106.72
									OCT 09 2020			
5	212181	647.1511	647.1500 E	Lower Deflector : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize Color Black, Prime as per Dwg 647.1500	Firmed X4		10/2/20	4 pcs	0 pcs	4 pcs	\$14.44/pcs	\$57.76
									OCT 09 2020			
6	212994	647.2011	647.2000 Rev N/C	Lower Strut : Various STC's Issue P/O: ANODIZE AS PER DWG Finish: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOUR BLACK PRIME IAW MIL-P-23377J TYPE I CLASS N	Firmed X4		10/2/20	4 pcs	0 pcs	4 pcs	\$16.69/pcs	\$66.76
									OCT 09 2020			
7	205066	647.7814	647.7800	Fwd Bracket : Various STC's Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg. 647.7800 Rev. A	Firmed X14		10/2/20	14 pcs	0 pcs	14 pcs	\$10.14/pcs	\$141.96
									OCT 09 2020			
Grand Total:												\$524.48

Plex 10/6/20 11:38 AM dart.lussier.patrick



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB047196**



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Please ensure to send the related invoice to hby_ap@dartaero.com.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Pack List

Number: 920930

Date: 08-Oct-20

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 ea	Part: 647.5710 GPS Mount Hard Black Anodize per MIL-A-8625, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-P-23377J, Type I, Class N (Customer Supplied), .1-2 Mil max Batch/Lot#: 5286641 Job: 28196 PO: POHB047196		Rev: NC Expiry Date: 5/16/22 Line: 4
4 ea	Part: 647.2011 Lower Strut Hard Anodize per MIL-A-8625F, Type III, Class 2, Black, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied) .0006-.0009" (.6-9 mils) per drawing Batch/Lot#: 5286641 Job: 28196 PO: POHB047196		Rev: NC Expiry Date: 5/16/22 Line: 5
4 ea	Part: 647.1511 Lower Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 5286641 Job: 28197 PO: POHB047196		Rev: E Expiry Date: 5/16/22 Line: 5



RECEIVED
OCT 08 2020
DART AEROSPACE LTD.

Made in Canada.

Made in Canada.

RECEIVED
OCT 08 2020
DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920930

Date: 08-Oct-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
14 ea	Part: 647.7814 Fwd Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5286641 Job: 28198 PO: POHB047196	Rev: A	Expiry Date: 5/16/22 Line: 7
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>OCT 08 2020</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. DAS 81 9-89			
Made in Canada.			

Entered:

JK

Date:

OCT 09 2020



NCR No.

20-8553

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>205066</u> Part No. <u>647.7814</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				
Date: <u>2019/18</u>		Sequence #: <u>110</u>		QTY Affected: <u>7</u> <u>14</u>		MRB (QSI042) DAS 55 9-89 SEP 25 2020		
Description Work Order Deviation Q.209 hole position is out of Tolerance +/- .005 - 0.683 dimension is 0.692" - 1.155 +/- .005 is 1.170" - 0.448 +/- .002 is 0.440"				Disposition <u>Scrap / no replace</u>				Completed By <u>JBD 20-02-08</u>
				Lead hand / Supervisor <u>BA 20-02-08</u>				
				QC / QA Coordinator DAS 55 9-89 SEP 25 2020				
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☒ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread						
		Other/Details:						